



STANDARD PRODUCTS

Assembly requirements and recommendations

Doping

Thread compound quantities for make-up are the same for VAM TOP FE as for VAM TOP.

The recommended thread compound for standard VAM TOP FE products is TOTAL TIFORA PG (non metallic thread compound with specific gravity of 0.91 g/cm³).

The recommended thread compound repartition is 2/3 on box end and 1/3 on pin. Extreme acceptable repartition is 1/2 on box and 1/2 on pin. Thread compound shall be applied evenly in order to get a uniform coating on all parts of the connection.

The recommended thread compound quantities are indicated in the following table. The given values are to be considered as minimum ones.

Recommended quantity of thread compound for the assembly of VAM TOP FE

Nominal OD	Thread compound volume (cm ³)
7"	25
7 5/8"	27
7 3/4"	28
8"	31
8 5/8"	37
9 5/8"	41
9 7/8"	43
10 3/4"	46
11 3/4"	59
11 7/8"	60
13 3/8"	67
13 5/8"	68
14"	70

NB. 8" and 14" dimensions only exist as Isolated Products (see TSLI 983 for more reference).

To determine the quantity to apply in terms of weight, it is needed the specific gravity of the thread compound. It is given in the table below the specific gravity of TOTAL TIFORA PG, as well as BOL PTC and standard API thread compound.

Specific gravity of some thread compounds

Thread compound	Specific Gravity (g.cm ⁻³)
TOTAL TIFORA PG	0.91
BOL PTC	1.10
Standard API 5A2 or 5A3	1.67

BOL PTC and standard API thread compound can be considered as acceptable though less preferred alternatives to TOTAL TIFORA PG. In all cases, it is recommended that the acceptability of the thread compound should be checked with the end user.

The following table gives the resulting corresponding weights for TOTAL TIFORA PG

Nominal OD	Thread compound quantity (g)
7"	23
7 5/8"	25
7 3/4"	26
8"	28
8 5/8"	34
9 5/8"	38
9 7/8"	40
10 3/4"	42
11 3/4"	54
11 7/8"	55
13 3/8"	61
13 5/8"	62
14"	64

Size (OD)	Nominal Weight	Wall Thickness	75-80-85 ksi			90-95-100 ksi		
			min.	opti.	max.	min.	opti.	max.
in. mm	lb/ft	in. mm	ft.lb N.m					
7" 177.80	23.00	0.317 8.05	9 180 12 450	10 200 13 830	11 220 15 210	10 080 13 660	11 200 15 180	12 320 16 700
	26.00	0.362 9.19	9 780 13 270	10 870 14 740	11 960 16 210	10 680 14 480	11 870 16 090	13 060 17 700
	29.00	0.408 10.36	10 240 13 890	11 380 15 430	12 520 16 970	11 140 15 100	12 380 16 780	13 620 18 460
	32.00	0.453 11.51	12 780 17 320	14 200 19 250	15 620 21 180	14 000 18 990	15 560 21 100	17 120 23 210
	35.00	0.498 12.65	15 070 20 430	16 740 22 700	18 410 24 970	16 600 22 510	18 450 25 010	20 300 27 510
	38.00	0.540 13.72	17 180 23 290	19 090 25 880	21 000 28 470	19 000 25 760	21 110 28 620	23 220 31 480
	41.00	0.590 14.99	19 680 26 680	21 870 29 650	24 060 32 620	21 850 29 630	24 280 32 920	26 710 36 210
	42.70	0.625 15.88	21 640 29 350	24 050 32 610	26 460 35 870	24 060 32 620	26 730 36 240	29 400 39 860
7 5/8" 193.675	26.40	0.328 8.33	11 090 15 030	12 320 16 700	13 550 18 370	12 320 16 700	13 690 18 560	15 060 20 420
	29.70	0.375 9.53	11 740 15 920	13 050 17 690	14 360 19 460	12 980 17 600	14 420 19 550	15 860 21 500
	33.70	0.430 10.92	12 490 16 940	13 880 18 820	15 270 20 700	13 720 18 610	15 250 20 680	16 780 22 750
	35.80	0.465 11.81	14 540 19 720	16 160 21 910	17 780 24 100	16 060 21 780	17 850 24 200	19 640 26 620
	39.00	0.500 12.70	16 580 22 470	18 420 24 970	20 260 27 470	18 400 24 940	20 440 27 710	22 480 30 480
	42.80	0.562 14.27	20 110 27 260	22 340 30 290	24 570 33 320	22 450 30 430	24 940 33 810	27 430 37 190
	45.30	0.595 15.11	22 040 29 880	24 490 33 200	26 940 36 520	24 660 33 440	27 400 37 150	30 140 40 860
	47.10	0.625 15.88	23 910 32 420	26 570 36 020	29 230 39 620	26 790 36 320	29 770 40 360	32 750 44 400
7 3/4" 196.85	46.10	0.595 15.11	22 460 30 450	24 950 33 830	27 450 37 210	25 110 34 050	27 900 37 830	30 690 41 610
8 5/8" 219.075	36.00	0.400 10.16	11 960 16 220	13 290 18 020	14 620 19 820	12 850 17 420	14 280 19 360	15 710 21 300
	40.00	0.450 11.43	15 760 21 370	17 510 23 740	19 260 26 110	17 190 23 300	19 100 25 890	21 010 28 480
	44.00	0.500 12.70	19 570 26 520	21 740 29 470	23 910 32 420	21 550 29 210	23 940 32 460	26 330 35 710
	49.00	0.557 14.15	23 870 32 360	26 520 35 950	29 170 39 540	26 440 35 850	29 380 39 830	32 320 43 810
	52.00	0.595 15.11	26 670 36 150	29 630 40 170	32 590 44 190	29 650 40 190	32 940 44 660	36 230 49 130
9 5/8" 244.475	40.00	0.395 10.03	11 540 15 640	12 820 17 380	14 100 19 120	12 400 16 810	13 780 18 680	15 160 20 550
	43.50	0.435 11.05	15 110 20 480	16 790 22 760	18 470 25 040	16 510 22 370	18 340 24 860	20 170 27 350
	47.00	0.472 11.99	18 430 24 990	20 480 27 770	22 530 30 550	20 320 27 550	22 580 30 610	24 840 33 670
	53.50	0.545 13.84	25 000 33 890	27 780 37 660	30 560 41 430	27 890 37 810	30 990 42 010	34 090 46 210
	58.40	0.595 15.11	29 420 39 890	32 690 44 320	35 960 48 750	32 980 44 700	36 640 49 670	40 300 54 640

Size (OD)	Nominal Weight	Wall Thickness	75-80-85 ksi			90-95-100 ksi		
			min.	opti.	max.	min.	opti.	max.
in. mm	lb/ft	in. mm	ft.lb N.m					
9 7/8" 250.825	62.80	0.625 15.88	34 050 46 160	37 830 51 290	41 610 56 420	38 440 52 110	42 710 57 900	46 980 63 690
	65.30	0.650 16.51	36 370 49 310	40 410 54 790	44 450 60 270	41 120 55 750	45 690 61 940	50 260 68 130
	66.40	0.661 16.79	37 390 50 690	41 540 56 320	45 690 61 950	42 290 57 340	46 990 63 710	51 690 70 080
	66.90	0.668 16.97	38 000 51 520	42 220 57 240	46 440 62 960	43 000 58 300	47 780 64 780	52 560 71 260
	67.50	0.678 17.22	38 910 52 750	43 230 58 610	47 550 64 470	44 050 59 720	48 940 66 350	53 830 72 980
	68.00	0.694 17.63	40 410 54 780	44 900 60 870	49 390 66 960	45 000 61 010	50 000 67 790	55 960 75 870
	68.90	0.700 17.78	40 900 55 460	45 450 61 620	50 000 67 780	45 000 61 010	50 000 67 790	56 660 76 810
	70.50	0.720 18.29	42 800 58 030	47 560 64 480	52 320 70 930	45 000 61 010	50 000 67 790	59 330 80 440
	72.00	0.725 18.42	43 230 58 610	48 030 65 120	52 830 71 630	45 000 61 010	50 000 67 790	59 940 81 260
	10 3/4" 273.05	45.50	0.400 10.16	13 620 18 460	15 130 20 510	16 640 22 560	14 860 20 140	16 510 22 380
51.00		0.450 11.43	19 010 25 770	21 120 28 630	23 230 31 490	21 090 28 590	23 430 31 770	25 770 34 950
55.50		0.495 12.57	23 860 32 350	26 510 35 940	29 160 39 530	26 700 36 210	29 670 40 230	32 640 44 250
60.70		0.545 13.84	29 230 39 630	32 480 44 030	35 730 48 430	32 910 44 620	36 570 49 580	40 230 54 540
65.70		0.595 15.11	34 670 47 000	38 520 52 220	42 370 57 440	39 210 53 160	43 570 59 070	47 930 64 980
71.10		0.650 16.51	40 690 55 160	45 210 61 290	49 730 67 420	45 000 61 010	50 000 67 790	56 460 76 550
73.20		0.672 17.07	43 060 58 380	47 850 64 870	52 640 71 360	45 000 61 010	50 000 67 790	59 830 81 110
11 3/4" 298.45		54.00	0.435 11.05	18 080 24 520	20 090 27 240	22 100 29 960	20 000 27 110	22 220 30 120
	60.00	0.489 12.42	24 810 33 640	27 570 37 380	30 330 41 120	27 810 37 700	30 900 41 890	33 990 46 080
	65.00	0.534 13.56	30 500 41 360	33 890 45 950	37 280 50 550	34 400 46 640	38 220 51 820	42 040 57 000
	71.00	0.582 14.78	36 590 49 610	40 660 55 120	44 730 60 630	41 480 56 240	46 090 62 490	50 700 68 740
11 7/8" 301.625	67.80	0.550 13.97	32 490 44 050	36 100 48 940	39 710 53 830	36 730 49 800	40 810 55 330	44 890 60 860
	71.80	0.582 14.78	36 580 49 590	40 640 55 100	44 700 60 610	41 470 56 220	46 080 62 470	50 690 68 720
13 3/8" 339.725	61.00	0.430 10.92	21 500 29 150	23 890 32 390	26 280 35 630	24 080 32 650	26 760 36 280	29 440 39 910
	68.00	0.480 12.19	29 470 39 950	32 740 44 390	36 010 48 830	33 380 45 250	37 090 50 280	40 800 55 310
	72.00	0.514 13.06	34 890 47 300	38 770 52 560	42 650 57 820	39 720 53 850	44 130 59 830	48 540 65 810
	77.00	0.550 13.97	40 690 55 160	45 210 61 290	49 730 67 420	45 000 61 010	50 000 67 790	56 830 77 040
	80.70	0.580 14.73	45 000 61 010	50 000 67 790	55 780 75 620	45 000 61 010	50 000 67 790	63 880 86 600
	85.00	0.608 15.44	45 000 61 010	50 000 67 790	61 180 82 950	45 000 61 010	50 000 67 790	70 190 95 160
	86.00	0.625 15.88	45 000 61 010	50 000 67 790	64 650 87 650	45 000 61 010	50 000 67 790	74 240 100 650
	13 5/8" 346.075	88.20	0.625 15.88	45 000 61 010	50 000 67 790	65 010 88 130	45 000 61 010	50 000 67 790

Size (OD)	Nominal Weight	Wall Thickness	105-110-115 ksi			120-125-130 ksi		
			min.	opti.	max.	min.	opti.	max.
in. mm	lb/ft	in. mm	ft.lb N.m					
7" 177.80	23.00	0.317 8.05	10 960 14 860	12 180 16 510	13 400 18 160	11 880 16 110	13 200 17 900	14 520 19 690
	26.00	0.362 9.19	11 570 15 690	12 860 17 430	14 150 19 170	12 490 16 940	13 880 18 820	15 270 20 700
	29.00	0.408 10.36	12 030 16 320	13 370 18 130	14 710 19 940	12 950 17 560	14 390 19 510	15 830 21 460
	32.00	0.453 11.51	15 210 20 620	16 900 22 910	18 590 25 200	16 460 22 320	18 290 24 800	20 120 27 280
	35.00	0.498 12.65	18 120 24 560	20 130 27 290	22 140 30 020	19 690 26 690	21 880 29 660	24 070 32 630
	38.00	0.540 13.72	20 810 28 210	23 120 31 340	25 430 34 470	22 670 30 740	25 190 34 150	27 710 37 560
	41.00	0.590 14.99	24 010 32 550	26 680 36 170	29 350 39 790	26 230 35 560	29 140 39 510	32 050 43 460
	42.70	0.625 15.88	26 450 35 860	29 390 39 850	32 330 43 840	28 920 39 200	32 130 43 560	35 340 47 920
7 5/8" 193.675	26.40	0.328 8.33	13 540 18 360	15 050 20 400	16 560 22 440	14 800 20 070	16 450 22 300	18 100 24 530
	29.70	0.375 9.53	14 200 19 250	15 780 21 390	17 360 23 530	15 470 20 980	17 190 23 310	18 910 25 640
	33.70	0.430 10.92	14 960 20 280	16 620 22 530	18 280 24 780	16 220 21 990	18 020 24 430	19 820 26 870
	35.80	0.465 11.81	17 590 23 840	19 540 26 490	21 490 29 140	19 150 25 960	21 280 28 850	23 410 31 740
	39.00	0.500 12.70	20 200 27 400	22 450 30 440	24 700 33 480	22 080 29 930	24 530 33 260	26 980 36 590
	42.80	0.562 14.27	24 770 33 580	27 520 37 310	30 270 41 040	27 150 36 810	30 170 40 900	33 190 44 990
	45.30	0.595 15.11	27 260 36 960	30 290 41 070	33 320 45 180	29 930 40 580	33 260 45 090	36 590 49 600
	47.10	0.625 15.88	29 640 40 180	32 930 44 640	36 220 49 100	32 570 44 150	36 190 49 060	39 810 53 970
7 3/4" 196.85	46.10	0.595 15.11	27 740 37 600	30 820 41 780	33 900 45 960	30 440 41 260	33 820 45 850	37 200 50 440
8 5/8" 219.075	36.00	0.400 10.16	13 730 18 620	15 260 20 690	16 790 22 760	14 650 19 860	16 280 22 070	17 910 24 280
	40.00	0.450 11.43	18 600 25 220	20 670 28 020	22 740 30 820	20 070 27 210	22 300 30 230	24 530 33 250
	44.00	0.500 12.70	23 500 31 860	26 110 35 400	28 720 38 940	25 520 34 600	28 350 38 440	31 190 42 280
	49.00	0.557 14.15	29 020 39 340	32 240 43 710	35 460 48 080	31 650 42 910	35 170 47 680	38 690 52 450
	52.00	0.595 15.11	32 620 44 220	36 240 49 130	39 860 54 040	35 670 48 360	39 630 53 730	43 590 59 100
9 5/8" 244.475	40.00	0.395 10.03	13 270 17 980	14 740 19 980	16 210 21 980	14 150 19 180	15 720 21 310	17 290 23 440
	43.50	0.435 11.05	17 900 24 270	19 890 26 970	21 880 29 670	19 330 26 210	21 480 29 120	23 630 32 030
	47.00	0.472 11.99	22 210 30 110	24 680 33 460	27 150 36 810	24 150 32 730	26 830 36 370	29 510 40 010
	53.50	0.545 13.84	30 740 41 680	34 160 46 310	37 580 50 940	33 700 45 690	37 450 50 770	41 200 55 850
	58.40	0.595 15.11	36 500 49 490	40 560 54 990	44 620 60 490	40 130 54 400	44 590 60 450	49 050 66 500

Size (OD)	Nominal Weight	Wall Thickness	105-110-115 ksi			120-125-130 ksi		
			min.	opti.	max.	min.	opti.	max.
in. mm	lb/ft	in. mm	ft.lb N.m					
9 7/8" 250.825	62.80	0.625 15.88	42 800 58 020	47 550 64 470	52 310 70 920	45 000 61 010	50 000 67 790	57 770 78 320
	65.30	0.650 16.51	45 000 61 010	50 000 67 790	56 010 75 930	45 000 61 010	50 000 67 790	61 940 83 970
	66.40	0.661 16.79	45 000 61 010	50 000 67 790	57 640 78 140	45 000 61 010	50 000 67 790	63 760 86 440
	66.90	0.668 16.97	45 000 61 010	50 000 67 790	58 610 79 450	45 000 61 010	50 000 67 790	64 850 87 910
	67.50	0.678 17.22	45 000 61 010	50 000 67 790	60 060 81 420	45 000 61 010	50 000 67 790	66 470 90 120
	68.00	0.694 17.63	45 000 61 010	50 000 67 790	62 470 84 690	45 000 61 010	50 000 67 790	69 180 93 790
	68.90	0.700 17.78	45 000 61 010	50 000 67 790	63 270 85 780	45 000 61 010	50 000 67 790	70 070 95 000
	70.50	0.720 18.29	45 000 61 010	50 000 67 790	66 300 89 880	45 000 61 010	50 000 67 790	73 480 99 620
	72.00	0.725 18.42	45 000 61 010	50 000 67 790	66 970 90 790	45 000 61 010	50 000 67 790	74 230 100 640
	10 3/4" 273.05	45.50	0.400 10.16	16 090 21 820	17 880 24 240	19 670 26 660	17 370 23 550	19 300 26 170
51.00		0.450 11.43	23 160 31 390	25 730 34 880	28 300 38 370	25 290 34 290	28 100 38 100	30 910 41 910
55.50		0.495 12.57	29 520 40 020	32 800 44 470	36 080 48 920	32 440 43 970	36 040 48 860	39 640 53 750
60.70		0.545 13.84	36 560 49 560	40 620 55 070	44 680 60 580	40 340 54 680	44 820 60 760	49 300 66 840
65.70		0.595 15.11	43 720 59 270	48 580 65 860	53 440 72 450	45 000 61 010	50 000 67 790	59 130 80 160
71.10		0.650 16.51	45 000 61 010	50 000 67 790	63 130 85 590	45 000 61 010	50 000 67 790	70 020 94 920
73.20		0.672 17.07	45 000 61 010	50 000 67 790	66 950 90 760	45 000 61 010	50 000 67 790	74 300 100 740
11 3/4" 298.45		54.00	0.435 11.05	21 910 29 700	24 340 33 000	26 770 36 300	23 870 32 360	26 520 35 950
	60.00	0.489 12.42	30 790 41 740	34 210 46 380	37 630 51 020	33 850 45 890	37 610 50 990	41 370 56 090
	65.00	0.534 13.56	38 300 51 920	42 550 57 690	46 810 63 460	42 300 57 350	47 000 63 720	51 700 70 090
	71.00	0.582 14.78	45 000 61 010	50 000 67 790	56 650 76 800	45 000 61 010	50 000 67 790	62 800 85 140
11 7/8" 301.625	67.80	0.550 13.97	40 950 55 520	45 500 61 690	50 050 67 860	45 000 61 010	50 000 67 790	55 370 75 080
	71.80	0.582 14.78	45 000 61 010	50 000 67 790	56 660 76 810	45 000 61 010	50 000 67 790	62 820 85 170
13 3/8" 339.725	61.00	0.430 10.92	26 660 36 140	29 620 40 160	32 580 44 180	29 300 39 730	32 560 44 140	35 820 48 550
	68.00	0.480 12.19	37 260 50 520	41 400 56 130	45 540 61 740	41 280 55 970	45 870 62 190	50 460 68 410
	72.00	0.514 13.06	44 500 60 340	49 450 67 040	54 400 73 740	45 000 61 010	50 000 67 790	60 420 81 920
	77.00	0.550 13.97	45 000 61 010	50 000 67 790	63 860 86 570	45 000 61 010	50 000 67 790	71 080 96 370
	80.70	0.580 14.73	45 000 61 010	50 000 67 790	71 930 97 520	45 000 61 010	50 000 67 790	75 000 101 680
	85.00	0.608 15.44	45 000 61 010	50 000 67 790	75 000 101 680	45 000 61 010	50 000 67 790	75 000 101 680
	86.00	0.625 15.88	45 000 61 010	50 000 67 790	75 000 101 680	45 000 61 010	50 000 67 790	75 000 101 680
	13 5/8" 346.075	88.20	0.625 15.88	45 000 61 010	50 000 67 790	75 000 101 680	45 000 61 010	50 000 67 790